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WHAT IS CLAIMED IS:

- 1 1. A game ball comprising:
2 a casing having a laced region; and
3 a lacing coupled to the laced region of the casing, the lacing having an
4 exposed surface comprised of an outer material that is compressible, resilient, and
5 tactile, the outer material having a modulus of elasticity of between 14 and 170 kg/cm²
6 and a tensile strength between 100 and 650 kg/cm².
- 1 2. The game ball of claim 1, wherein the lacing further comprises an inner
2 substrate coupled to an outer layer.
- 1 3. The game ball of claim 2, wherein the outer layer is attached to the inner
2 substrate using a means selected from the group consisting of adhesive bonding,
3 stitching, stapling, mechanical bonding, heat bonding and combinations thereof.
- 1 4. The game ball of claim 2, wherein the inner substrate is formed from
2 one or more inner materials selected from the group consisting of a woven cloth, a non-
3 woven cloth, a urethane impregnated cloth, at least one nylon strand, at least one
4 polyester strand, braided fibers, plastic, latex, vinyl, a rope, a wire, a leather strip and
5 a combination thereof.
- 1 5. The game ball of claim 2 wherein the inner substrate includes at least
2 one strand of a high tensile strength material and a plastic generally surrounding to the
3 strand.
- 1 6. The game ball of claim 5 wherein the at least one strand is formed of a
2 strand material selected from the group consisting of a polyester, a nylon, a metal and a
3 polymer.

1 7. The game ball of claim 1 wherein the outer material has a modulus of
2 elasticity of between 30 and 110 kg/cm² and a tensile strength between 450 and 600
3 kg/cm².

1 8. The game ball of claim 1 wherein at least a portion of the exposed
2 surface includes a pebbled texture.

1 9. The game ball of claim 1 wherein the outer material is selected from the
2 group consisting of a wet process polyurethane, a dry process polyurethane, a
3 polyvinylchloride foam, and a combination thereof.

1 10. The game ball of claim 1 wherein the casing has a generally prolate
2 spheroidal shape having a major longitudinal dimension and a minor transverse
3 dimension, wherein the casing has a central portion disposed between first and second
4 end portions, wherein the laced region is disposed on the central portion, and wherein
5 the lacing includes at least one longitudinally extending segment and a plurality of
6 transversely extending segments.

1 11. The game ball of claim 10, wherein the plurality of transversely
2 extending segments comprises eight transversely extending segments.

1 12. The game ball of claim 2, wherein the inner substrate has a top side and
2 a bottom side, and wherein the outer layer is attached only to the top side.

1 13. The game ball of claim 2, wherein the inner substrate has a top side and
2 a bottom side, and wherein the outer layer is attached only to the top side and the
3 bottom side.

1 14. The game ball of claim 2, wherein the outer layer substantially surrounds
2 the inner substrate.

1 15. The game ball of claim 1, wherein the casing is substantially and
2 primarily formed in a first color and the exposed surface of the lacing is formed in a
3 second color, and wherein the first and second colors are substantially the same color.

1 16. The game ball of claim 1 wherein the casing is substantially and
2 primarily formed in a first color and the exposed surface of the lacing is formed in a
3 second color, and wherein the first and second colors are different colors.

1 17. A game ball comprising:
2 a casing having a laced region; and
3 a lacing coupled to the laced region of the casing, the lacing having an
4 exposed surface, at least a portion of the exposed surface of the lacing having a
5 pebbled texture.

1 18. The game ball of claim 17, wherein the entire exposed surface of the
2 lacing includes the pebbled texture.

1 19. The game ball of claim 17, wherein the lacing further comprises an inner
2 substrate and an outer layer, wherein the outer layer includes the exposed surface, and
3 wherein the inner substrate is formed from one or more materials selected from the
4 group consisting of a woven cloth, a non-woven cloth, a urethane impregnated cloth, at
5 least one nylon strand, at least one polyester strand, a metal wire, a plastic, a vinyl, a
6 polymer, a latex, a rope, a leather strip and a combination thereof.

1 20. The game ball of claim 17 wherein the inner substrate includes at least
2 one strand of a high tensile strength material, and a plastic attached to and generally
3 surrounding the strand.

1 21. The game ball of claim 19 wherein the outer layer is made of an outer
2 material selected from the group consisting of a wet process polyurethane, a dry
3 process polyurethane, a polyvinylchloride foam, and a combination thereof.

1 22. The game ball of claim 17 wherein the casing has a generally prolate
2 spheroidal shape having a major longitudinal dimension and a minor transverse
3 dimension, wherein the casing has a central portion disposed between first and second
4 end portions, wherein the laced region is disposed on the central portion, and wherein
5 the lacing includes at least one longitudinally extending segment and a plurality of
6 transversely extending segments.

1 23. The game ball of claim 17 wherein the casing is substantially and
2 primarily formed in a first color and the exposed surface of the lacing is formed in a
3 second color, and wherein the first and second colors are substantially the same color.

1 24. The game ball of claim 17 wherein the casing is substantially and
2 primarily formed in a first color and the exposed surface of the lacing is formed in a
3 second color, and wherein the first and second colors are different colors.

1 25. The game ball of claim 17 wherein the casing includes a plurality of lace
2 holes and wherein the lacing is threaded to the casing through the lace holes.

1 26. The game ball of claim 17 wherein the lacing is integrally formed to the
2 casing.

1 27. A game ball comprising:
2 a casing having a laced region; and
3 a lacing coupled to and generally surrounding the laced region of the
4 casing, the lacing including an inner substrate attached to an outer layer, the outer layer
5 of the lacing having an exposed surface made of an outer material that is compressible,
6 resilient, and tactile.

1 28. The game ball of claim 27, wherein at least a portion of the exposed
2 surface includes a pebbled texture.

1 29. A lacing for a sporting goods product, the lacing comprising:
2 an inner substrate of high tensile strength material; and
3 an outer layer coupled to the inner substrate, the outer layer being made
4 of a material that is soft, compressible, resilient, and tactile, the material of the outer
5 layer having a modulus of elasticity of between 14 and 170 kg/cm² and a tensile
6 strength between 100 and 650 kg/cm².

1 30. The lacing of claim 29, wherein the sporting goods product is selected
2 from the group consisting of an American football, a volleyball, a soccer ball, a
3 basketball, a rugby ball, and a baseball mitt.

1 31. The lacing of claim 29, wherein the outer layer is coupled to the inner
2 substrate using a means selected from the group consisting of adhesive bonding,
3 stitching, stapling, mechanical bonding, heat bonding and combinations thereof.

1 32. The lacing of claim 29, wherein the inner substrate is formed from at
2 least one material selected from the group consisting of a woven cloth, a non-woven
3 cloth, a urethane impregnated cloth, at least one nylon strand, at least one polyester
4 strand, a plastic, a metal wire, a polymer, a latex, a rope, a leather strip and a
5 combination thereof

1 33. The lacing of claim 29 wherein the inner substrate includes at least one
2 strand of a high tensile strength material and a plastic attached to the strand.

1 34. The lacing of claim 29 wherein the material of the outer layer has a
2 modulus of elasticity of between 30 and 110 kg/cm² and a tensile strength between 450
3 and 600 kg/cm².

1 35. The lacing of claim 29 wherein the outer layer has an exposed surface,
2 and wherein at least a portion of the exposed surface is pebbled.

1 36. The lacing of claim 29 wherein the material of the outer layer is selected
2 from the group consisting of a wet process polyurethane, a dry process polyurethane, a
3 polyvinylchloride foam, and a combination thereof.

1 37. The lacing of claim 29, wherein the inner substrate has a top side and a
2 bottom side, and wherein the outer layer is attached only to the top side.

1 38. The lacing of claim 29, wherein the inner substrate has a top side and a
2 bottom side, and wherein the outer layer is attached only to the top side and the bottom
3 side.

1 39. The lacing of claim 29, wherein the outer layer substantially surrounds
2 the inner substrate.